

CLAIMS

What is claimed is:

1. A method of making a laminate compliant with ASTM F1670-95 comprising:
 - treating a nonwoven web with a surfactant;
 - 5 heating a multilayer film having at least one layer comprising a micropore developing filler;
 - stretching the multilayer film to a percentage of its unstretched state during the heating step; and
 - thermally bonding the multilayer film to the surfactant treated nonwoven web.
- 10 2. The method of claim 1 further comprising retracting the multilayer film a lesser percentage prior to bonding the film to the nonwoven web.
3. The method of claim 1 wherein at least one layer of the multilayer film comprises about 30% to about 75% by weight polyolefin resin and from about 70% to about 25% by weight of filler having an average size less than about 10 microns.
- 15 4. The method of claim 1 further comprising a CATALLOY polymer for at least one layer of the multilayer film.
5. The method of claim 1 further comprising bonding a second nonwoven web to the laminate such that the multilayer film is disposed between the two nonwoven webs.
6. The method of claim 1 wherein the multilayer film is maintained at temperatures between about 160 degrees F and about 220 degrees F while the film is stretched.
- 20 7. The method of claim 2 wherein the multilayer film is maintained at temperatures between about 160 degrees F and about 220 degrees F while the film is retracted.
8. The method of claim 1 wherein the multilayer film is stretched at least about 200 percent of its original length.
- 25 9. The method of claim 1 wherein the multilayer film is stretched between about 250 to about 500 percent of its original length.
10. The method of claim 1 wherein the multilayer film is stretched at least about 300 percent of its original length.

11. The method of claim 1, wherein the laminate, tested per NFPA 702-1980, meets the 20 second or greater flame propagation criteria for a Class 1 material.

12. A method of making a laminate compliant with ASTM F1670-95 comprising:

- treating at least one surface of a nonwoven web with a surfactant;
- 5 forming an outer layer from the treated nonwoven web;
- heating a multilayer film having at least one layer comprising a micropore developing filler and at least one skin layer;
- stretching the multilayer film to at least 200 percent of its unstretched state while applying heat to the film;
- 10 juxtaposing the multilayer film onto the treated nonwoven web so that the skin layer contacts the surfactant treated surface; and
- thermally bonding the film to the surfactant treated surface.

13. The method of claim 12 further comprising retracting the multilayer film a lesser percentage prior to bonding the film to the nonwoven web.

15 14. The method of claim 12 further comprising retracting the multilayer film about 20 percent of its final stretched state.

15. The method of claim 12, wherein the laminate, tested per NFPA 702-1980, meets the 20 second or greater flame propagation criteria for a Class 1 material.

16. The method of claim 12, wherein the surfactant is coated onto the surface of the nonwoven web.

20 17. The method of claim 12, wherein film is maintained at temperatures between about 160 degrees F and about 220 degrees F while the film is stretched.

18. The method of claim 13 wherein the film is maintained at temperatures between about 160 degrees F and about 220 degrees F while the film is retracted.

19. The method of claim 12, for the manufacture of a surgical drape.

25 20. The method of claim 12 wherein a water vapor transmission test (WVTR), as measured by test method ASTM Standard E96-80 yields a value of greater than about 300 g/m² /day.